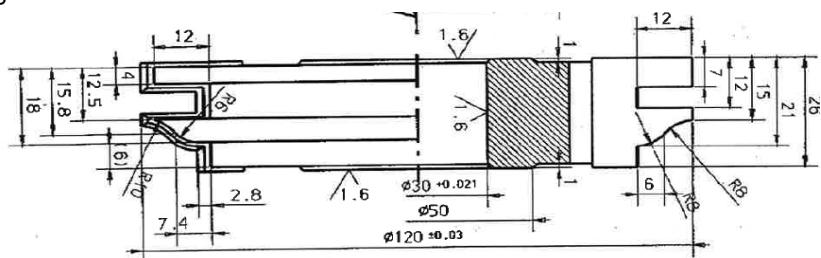


# ShearAngle Profile Tool Ø120 Z4

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A16-200

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels and automatic calculation of the wheelorientation to achieve the required radial and axial clearance. Probing is measuring Shear-, Rakeangle and division if necessary.



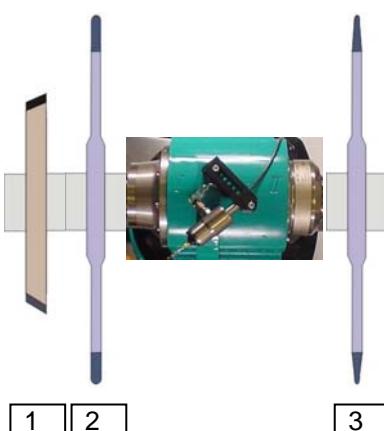
## 1. Cycletime for Production

Workpiece:	Ø 120 mm, Z 4, Length of cutting edge 26 mm Material CARBIDE				
Operations	Probe	Flute 1	Prf Rough	Prf Pgrd	Prf fin
Feed [mm/Min]	2000	70	90	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	3
Grinding time [s]	30	183	809	165	120
Total cycle time	21 Min 47				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	14EE1 Ø200 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CEG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

#### Accessories:

Responsible engineer: OP 3.8.10

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